

Date: Wednesday, 03/12/2008 7:01:22 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 43890		Part Number	: D37911		
Estimate Number	: 13309		Drawing Number	: D3791 REVA		
P.O. Number	:		Project Number	: N/A		
This Issue	: 03/12/2008	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SMALL /MED FAB			
Previous Run	: 42982		Due Date	: 10/12/2008		Qty: 12 Um: Each
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 Sheet .063 
<b>Comment:</b> Qty.: 0.3063 sf(s)/Unit Total : 3.6754 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>109057</u> <u>HB 8-12-11</u>		
2.0	WATER JET	FLOW WATER JET 
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3791 Dwg Rev: <u>A</u> <u>HB 8-12-11</u> Prog Rev: <u>A</u> <u>(12)</u>		
2-Deburr if necessary <u>HB 8-12-11</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <u>HB 8-12-11</u>
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK  <u>HB 8-12-11</u> <u>(12)</u>
<b>Comment:</b> SECOND CHECK		
5.0	BRAKE NC	NC BRAKE  <u>HB 8-12-11</u> <u>(12)</u>
<b>Comment:</b> NC BRAKE <u>Deburr if necessary</u> <u>HB 8-12-11</u> <u>(12)</u>		
2-Form on Brake as per Dwg D3791 using Jigs <u>HB 8-12-11</u> <u>(12)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/12/2008 7:01:22 AM  
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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 08/12/11 x12

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M109963

EL 8-12-15 x12

8.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/12/15 x12

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15 x12

10.0 POWDER COATING

POWDER COATING



M 109648

12x

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

1:50

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320  
2:20

M-1 08/12/15

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/12/15

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker and Stock  
Location: FP-17

FX 08/12/15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 43890

Part Number: D37911

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



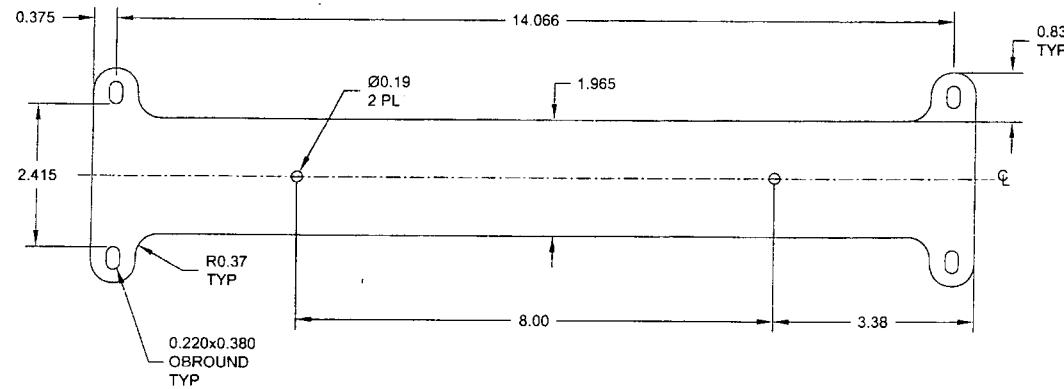
MF 08-12-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

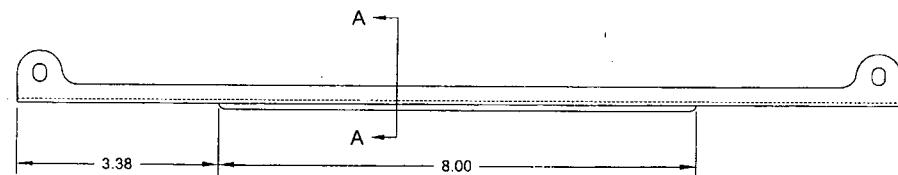
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3791-1F FLAT PATTERN**



**D3791-1 WEARPLATE**  
(MAKE FROM D3791-1F)

## NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)  
2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.015  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH  
7) WEIGHT: 0.70 LBS  
8) WELD PER DART QSI 004



RELEASED  
06-05-21 110

A	NEW ISSUE	PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC</b>	
DRAWN	<i>PH</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3791	SHEET 1 OF 1
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	WEARPLATE	NTS
DATE	08.05.13	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE USA, INC.	

DART AEROSPACE LTD	Work Order:	43890
Description: WEAR PLATE	Part Number:	D3791-1
Inspection Dwg: D3791-1 Rev: A		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **x First Article      x Prototype**

Measured by: B	Audited by: S	Prototype Approval: A
Date: 8-12-11	Date: 08/12/11	Date: 11/12/11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	